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D205-541-055
Job Sheet 193074



Part No: D205-541-055

Job Qty: 2 pcs

Part Name: Bell Medium Basket Quick Release Retrofit



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/8/19

Job Tracking No:

Due Date: 5/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 4922*

Note: DWG REV B IPP REV:A 16.12.06 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs		5/1/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Container No: S178049

Part: D205-541-055

Job No: 193074

Serial No/Batch: S178049

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96 - 120 Issues 2, 5A, 6A, 6B, 6C SR0069

120	QC 4	2 pcs	5/1/19	0.00 0.00	Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					QC 4 - 28	
120	QC 4	2 pcs	5/1/19	0.00 0.00	QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	DAS 46 MAY 06 2019
	130 Packaging 3-1 - Stock - B4B	2 pcs	5/1/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS 46 MAY 06 2019
					Packaging 3 - 2 - B4B	9-89
					Packaging 3 - 3 - B4B	46 MAY 06 2019
					Packaging 3 - 4 - B4B	9-89
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21 MAY 06 2019
135	DC - 1 - B4B	2 pcs	5/1/19	0.00 0.00	DC - 1 - B4B	21 MAY 06 2019
					DC - 2 - B4B	9-89
140	QC 21 - FG	2 pcs	5/1/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	DAS 21 MAY 06 2019
					QC 21 - SA - 53	9-89

Part Op 120 - (QC4- 100% Inspect kits for completeness)

Descriptions: 130 - (Identify as per dwg & Stock Location: _____), Identify and pack for shipping as per PPP D205-541-055

135 - Photocopy bluefile & type labels per PPP D205-541-055 CHG001

140 - (QC21- Final Inspection - Work Order Release)

009600

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2690-6	Lanyard	6 pcs (3 ea)	110-Packaging 1 - Pick Kit	51763221
D5407-041	Strut Assembly	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51559601
D5407-043	Strut Assembly	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51559535
D5407-045	Strut Assembly	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5176322x1 515597x1
D5457-1	Mounting Lug	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51558887
D5458-1	Bushing	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	51765111
MS17984-C411	Quick Release Pip Pin	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	FM136579
MS17984-C413	Quick Release Pin	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51765200
MS17984-C510	Pin, Quick Release	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	51765200
NAS1149D0416J	Washer	6 Ea (3 ea)	110-Packaging 1 - Pick Kit	FM131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D2690-6	6	42	0
	D5407-041	2	2	0
	D5407-043	2	3	0
	D5407-045	2	1	0
	D5457-1	2	4	0
	D5458-1	4	6	0
	MS17984-C411	2	4	0
	MS17984-C413	2	55	0
	MS17984-C510	2	6	0
	NAS1149D0416J	6	2,050	0

Part Specifications

Specifications could not be found.

Plex 4/8/19 11:26 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

3.0 300 HOUR INSPECTION

Update 300 Hour inspection in ICA-D205-541 to include the following items:

- 3.1 All visible areas of the installation should be checked for mechanical damage (scratches, nicks, wear) and corrosion according to Table 1. Replace parts that have been damaged beyond limits.
- 3.2 Inspect the condition of the hardware for suitability for continued service.

Table 1 - Damage Limits

Location	Type of Damage	Max. Allowable Damage	Repair
D5407-041/-043/-045 Strut Assembly D5457-1 Mounting Lug	Nicks, Scratches, Corrosion	Up to 0.010" (0.25 mm) deep	Acceptable. Polish out to a maximum depth of 0.010" (0.25 mm) using scotchbrite
		Over 0.010" (0.25 mm) deep	None, replace part
	Elongated Holes	Up to 0.025" (0.64 mm) across hole diameter	Acceptable
		Over 0.025" (0.64 mm) across hole diameter	None, replace part
	Cracks/Dents/Bending/Yielding	None	None, replace part

4.0 WEIGHT AND BALANCE

The net weight and balance for the D205-541-051 Quick Release Retrofit kit is shown in the table below:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-055 Quick Release Retrofit kit	1.46 lb 0.66 kg	48.50 in 1.23 m	70.8 in-lb 0.81 m-kg	118.80 in 3.02 m	173.4 in-lb 1.99 m-kg

5.0 PARTS LIST

Qty -055	Part Number	Description
X	D205-541-055	QUICK RELEASE RETROFIT
3	D2690-6	LANYARD ASSEMBLY
1	D5407-041	STRUT ASSEMBLY
1	D5407-043	STRUT ASSEMBLY
1	D5407-045	STRUT ASSEMBLY
1	D5457-1	MOUNTING LUG
2	D5458-1	BUSHING
1	MS17984-C411	PIP PIN
1	MS17984-C413	PIP PIN
1	MS17984-C510	PIP PIN
3	NAS1149D0416J	WASHER

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9747	SHEET 2 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	QUICK RELEASE RETROFIT	NTS
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